



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2662-2

Job Sheet 208678



Part No: D2662-2

Job Qty: 4 pcs

Part Name: Saddle, LH Fwd, Aft, Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/30/20

Job Tracking No:

Due Date: 4/15/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG REV E IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP REV:D REDESIGN
PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	4 pcs	4/14/20		1.00	4.96	HAAS - 1		
							HAAS - 2		
							HAAS - 3		SBL 20/04/22
							HAAS - 4		
110	Conventional Mill - 1 - B4B	4 pcs	4/14/20		0.00	1.02	Conventional Mill - 1 - B4B		SBL 20/04/22
							Conventional Mill - 2 - B4B		
120	QC 2	4 pcs	4/14/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S272290



Part: D2662-2

Job No: 208678

Serial No/Batch: S272290

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/21/20

						QC 2 - 57	SBL 20/04/22
						QC 2 - 62	
						QC 2 - 63	
						QC 2 - 8	
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
						QC 2 - 76	
						QC 2 - 86	
130 QC 8	4 pcs	4/14/20	0.00	0.00		QC 8 - 12	mk 20/04/22
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
						QC 8 - 57	
						QC 8 - 76	
						QC 8 - 61	
						QC 8 - 66	
140 Handfinish - 1-1 Chemical-B4B	4 pcs	4/14/20	0.00	0.12		Handfinish - 1 - 1 - B4B	BER 20-04-22
						Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	

				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White GI(A)- B4B	4 pcs	4/15/20	0.00 0.12	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
160	QC 3	4 pcs	4/15/20	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
					QC 3 - 19
					QC 3 - 43
					QC 3 - 24
					QC 3 - 61
					QC 3 - 81
					QC 3 - 82
					QC 3 - 87
170	Packaging 3-1 - Stock - B4B	4 pcs	4/15/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 37 - B4B
180	QC 21 - SA	4 pcs	4/15/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
					Broussard

Part Op 100 - (HAAS CNC Vertical Machine), Program part number and batch number. Inspect part number and batch number are
 Descriptions: programmed MACHINE AS PER FOLIO FB069 & DWG DWG REV: F FOLIO REV: AA
 110 - (Manufacture as per dwg), Machine Keyway and inspect per attached dimension sheet
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check

140 - Chemical Conversion Coat per QSI005 4.1**150** - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

160 - QC3- Inspect Part Finish**170** - Identify as per dwg & Stock Location: _____**180** - QC21- Final Inspection - Work Order Release**Job BOM**

Part / Item	Component Name	Quantity	Operation	Container
D6101-001	Saddle Billet	4 pcs (1 ea)	100-HAAS 4 Axis	S235965

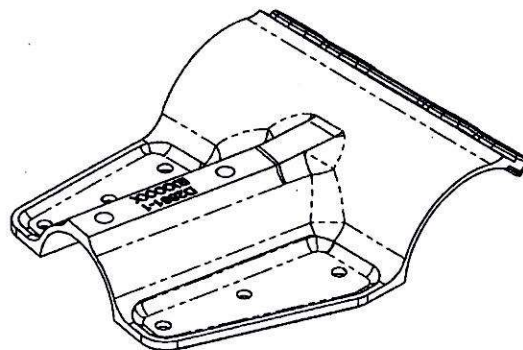
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-001	4	32	0

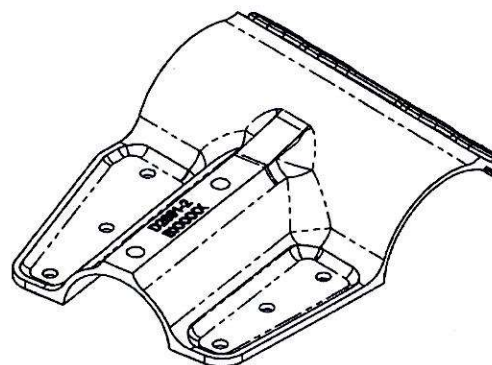
Part Specifications

Specifications could not be found.

Plex 3/30/20 1:11 PM Dart.Renwick.Jennifer



D2661-1 SADDLE, OUTSIDE, LH

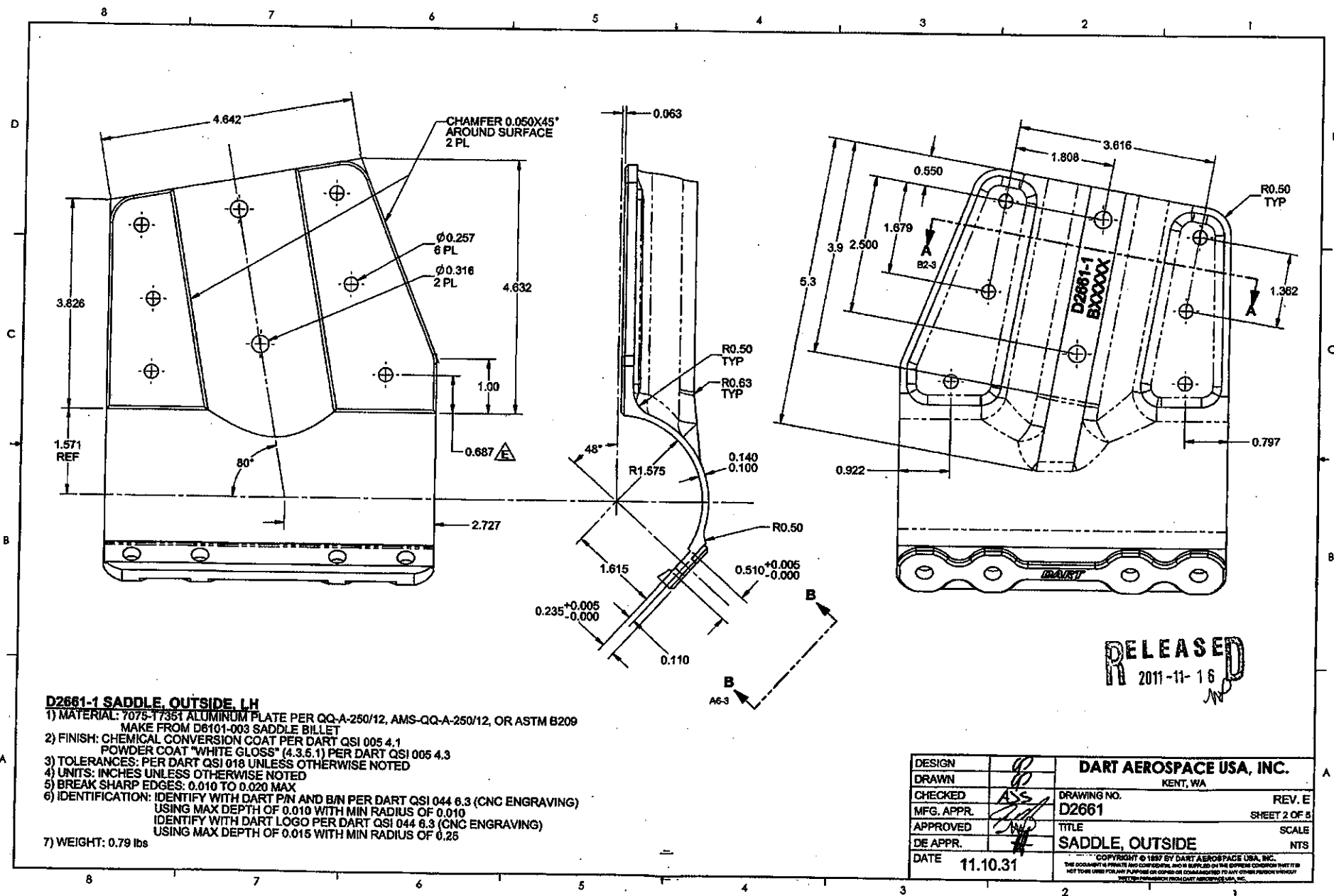


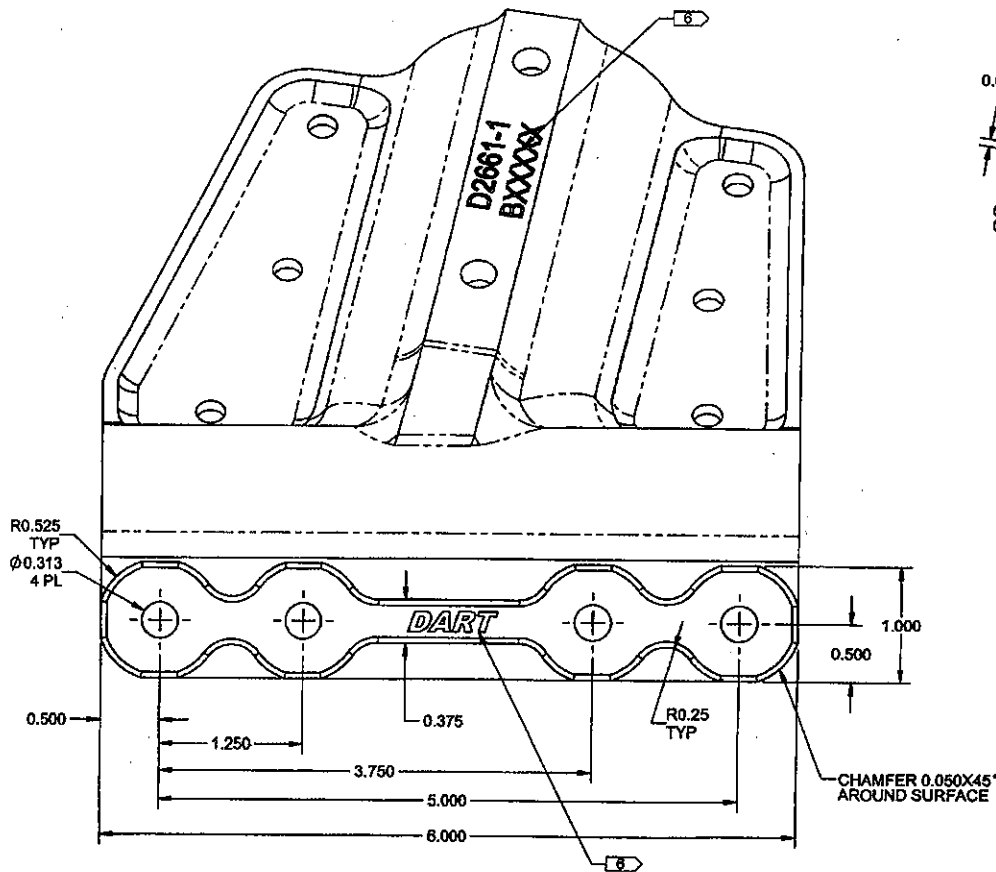
D2661-2 SADDLE, OUTSIDE, RH

RELEASED
2011-11-16

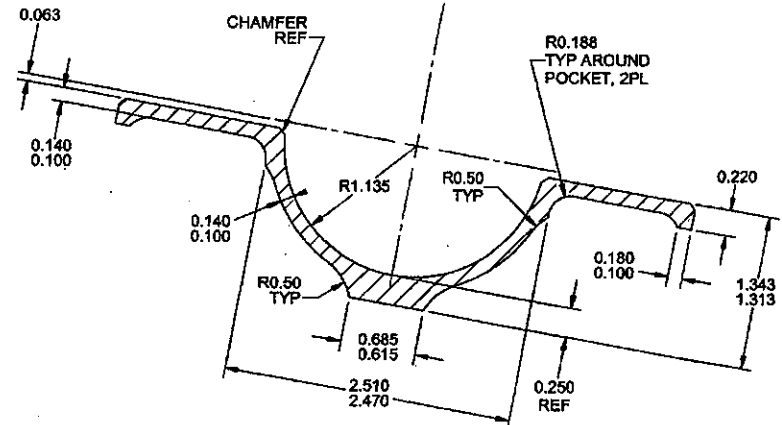
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 208678

E	REDRAW & REFORMAT DWG: 0.687 WAS 0.547 (B6-2,B6-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$	CB	08.11.08
C	INCORPORATE DEO 9122, 9102, 9095	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	07.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, OUTSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1987 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CONVEYED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	





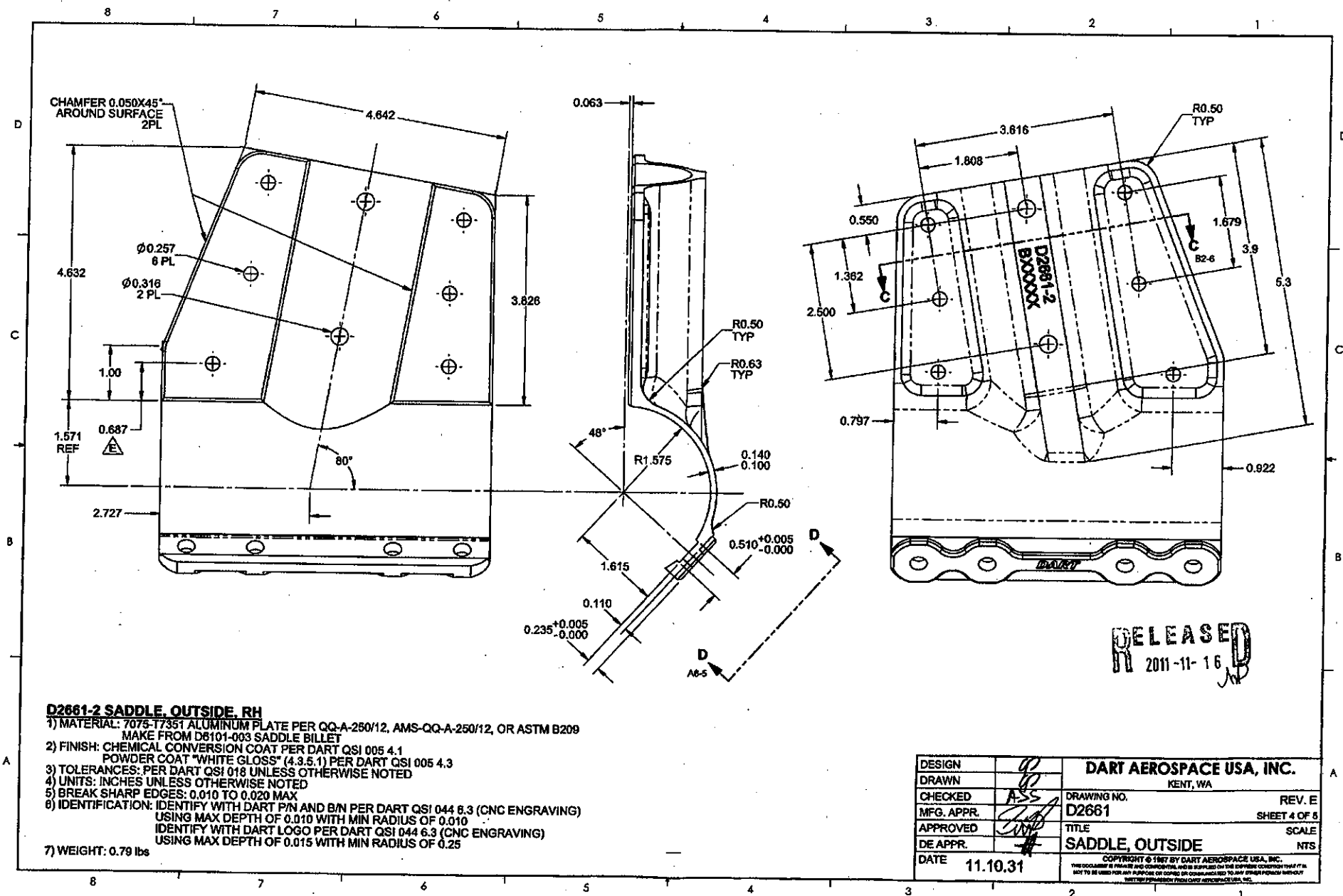
VIEW B-B
SCALE 1.5X
VIEW ROTATED

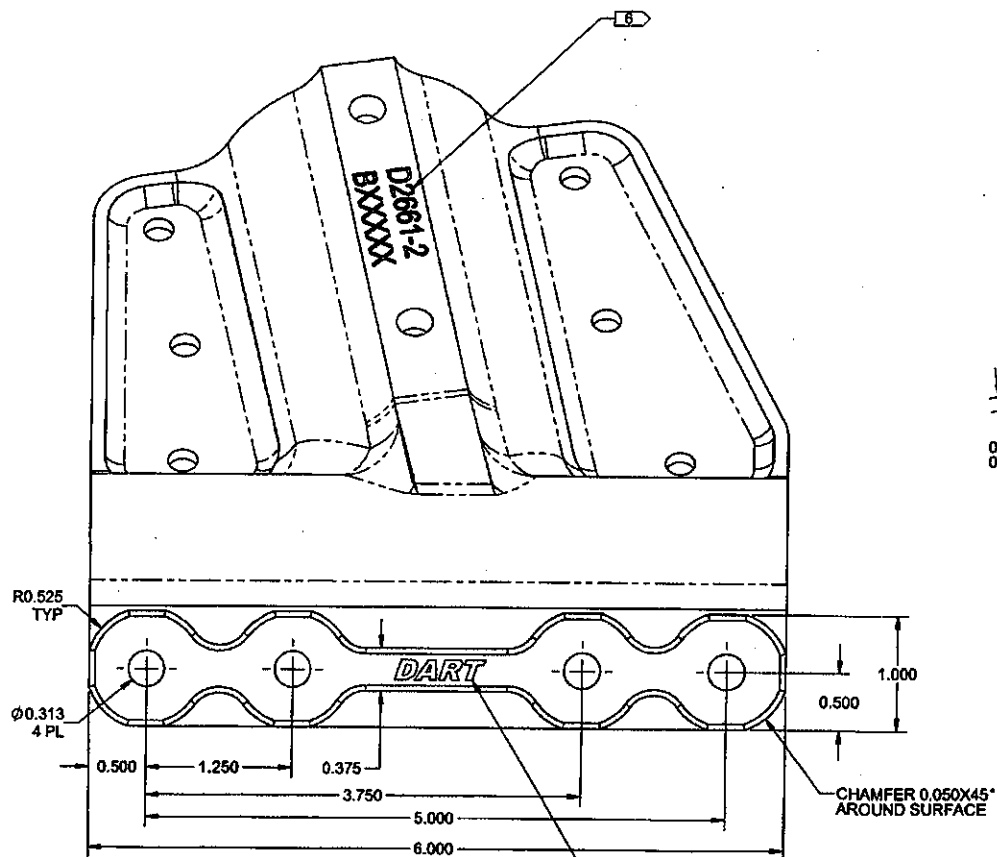


VIEW A-A
SCALE 1.5X

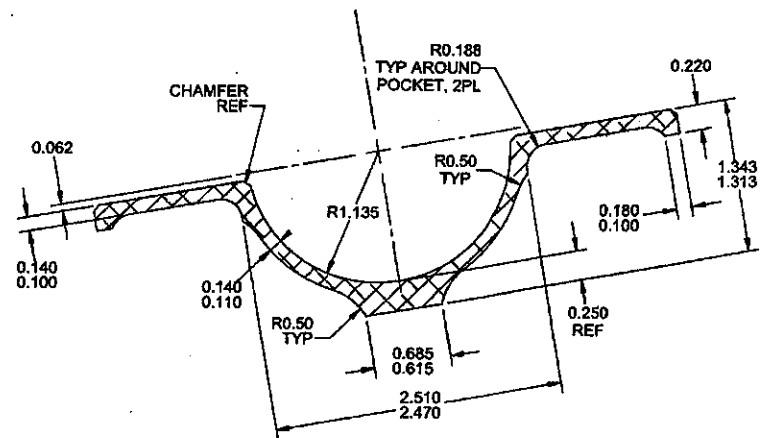
RELEASED
2011-11-16

DESIGN	90	DART AEROSPACE USA, INC.	
DRAWN	AS	KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 3 OF 5
APPROVED	JWB	TITLE	SCALE
DE APPR.	#	SADDLE, OUTSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC.	
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			





VIEW D-D B4-1
SCALE 1.5X
VIEW ROTATED



SECTION C-C C1-4
SCALE 1.5X

RELEASED
2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED	ASS	DRAWING NO. D2661	REV. E
MFG. APPR.		TITLE	SHEET 5 OF 5
APPROVED		SADDLE, OUTSIDE	SCALE
DE APPR.			NTS
DATE	11.10.31	COPYRIGHT © 1987 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPLICIT CONDITION THAT IT NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

DART AEROSPACE LTD		Work Order: 208678
Description: 206 Saddle, Inboard, Left side		Part Number: D2662-2
Inspection Dwg: D2662	Rev: E	DSK: Rev: Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.616			
B	0.256	0.263		.258	.258			
C	0.315	0.322		.316	.316			
D	2.495	2.505		2.500	2.500			
E	1.674	1.684		1.679	1.679			
F	0.100	0.140		.120	.120			
G	0.210	0.230		.220	.220			
H	0.615	0.685		.665	.665			
I	2.470	2.510		2.493	2.494			
J	1.313	1.343		1.322	1.323			
K	0.178	0.198		.188	.188			
L	0.470	0.530		.500	.500			
M	1.125	1.145		1.135	1.135			
N	0.100	0.180		.130	.132			
O	0.100	0.140		.135	.136			
P	0.240	0.260		.250	.247			
Q	0.677	0.697		.688	.688			
R	0.540	0.560		.550	.550			
S	0.912	0.932		.921	.921			
T	0.787	0.807		.797	.796			
U	5.990	6.010		6.002	6.002			
V	4.995	5.005		5.000	5.000			
W	0.490	0.510		.502	.502			
X	0.312	0.319		.313	.313			
Y	0.990	1.010		.998	.998			
Z								
AA	1.245	1.255		1.250	1.250			
AB	0.490	0.510		.499	.499			
AC	3.745	3.755		3.750	3.750			
AD	0.100	0.140		.135	.135			
AE	0.235	0.240		.239	.239			
AF	0.510	0.515		.511	.511			
AG	0.100	0.120		.110	.110			
AH	1.565	1.585		1.575	1.575			

Accept/Reject

Measured by: SBL	Date: 20/04/22
Audited by: [Signature]	Date: 20/04/22
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	
H	12.03.08	Dimension AH added, O revised	KJ	[Signature]